

Work Order ID 63954

Monday, November 22, 2010 9:15:55 AM



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 11/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-11-26 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3512	Rev C

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 . 663

Memo

0.00

PB 10-11-26

(18)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

Memo

0.00

PB 10-11-26

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

Memo

0.00

8.01u26

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

Brake NC

Memo

0.00

13

Brake NC

Deburr if necessary□Form as per dwg D3512 using DT8179

SB 10/11/29

140



QC5- Inspect part completeness to step on W/O

0.00

S.010/29

QC

Memo

0.00

712

Quality Control

150



Large Fab

0.00

EZ 10-12-22

X/2

Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004□Qty
Description Batch□A/R 2059b Hardcoat Rod M116399

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/12/02

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/12/22

(H2)

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588.

Memo

0.00

START TIME:

11:20

OVEN TEMPERATURE:

320

11:50

12 BR10-12-22

W/O:		WORK ORDER CHANGES					
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Monday, November 22, 2010 9:15:55 AM

Item ID: D3512-1

Accept



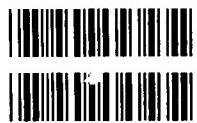
Setup



Revision ID:

Item Name: Wearplate

Start



Start Date: 11/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/29/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00

M 10/12/22

12 0

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: SOO

0.00

10/12/22 SL (12)

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/12/23 (12)

10/12/23
(12)

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Picklist Print

Page 1

Monday, November 22, 2010 9:15:59 AM

Work Order ID: 63954



Parent Item: D3512-1



Parent Item Name: Wearplate

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	140.6000	0.261	2.747368		11/20/11-26	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT	140.6	
111323	0	
115688	3.6	
115953	137	115953

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DART AEROSPACE LTD	Work Order:	63934
Description: Wearplate	Part Number:	D3512-1
Inspection Dwg: D3512 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>BS</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-11-26	Date:	10/4/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	08.01.16	Dimensions updated per Dwg Rev C	KJ/EC/DD	

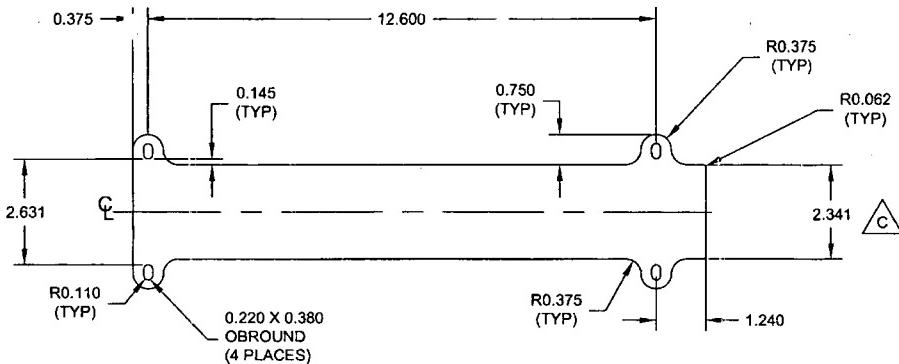
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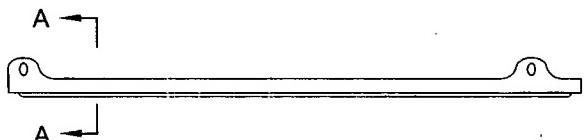
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D3512-1F FLAT PATTERN

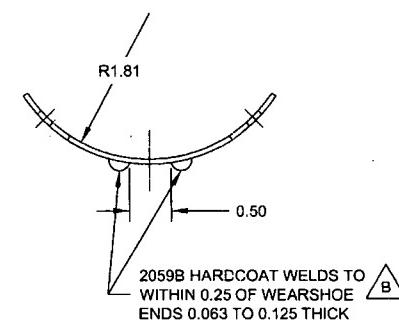


D3512-1 BENDING DETAIL

C

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs



SECTION A-A
SCALE 2:3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13934

07.10.05-22

RELEASED
07.11.16

C	ENLARGE OBROND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05	
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27	
A	NEW ISSUE	PH	06.04.21	
REV.	DESCRIPTION			
DESIGN	<i>14</i>	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	<i>14</i>	DRAWING NO.	REV. C	
CHECKED	<i>14</i>	D3512	SHEET 1 OF 1	
MFG. APPR.	<i>14</i>	APPROVED	SCALE	
DE APPR.	<i>14</i>	DE APPR.	WEARPLATE	
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE THAN THAT FOR WHICH IT WAS PROVIDED. NO OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	1:3	

8 7 6 5 4 3 2 1

D

C

B

A

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